5/43

DART AEROSPACE LTD	Work Order:	24635		
Description: Wearplate	Part Number:	D3321-3		
Dwg: D3321 Rev. X page ₹ 2 ∰.	Qty:	10		
B 05,10,21 64 AH		Page 1 of 1		

Step	Location	Procedure	Ву∧	Date	Qty
1	DC	Issue Traveler	PS	05.10,21	10
2	PG	Issue P/O: 20082(3			
		Email or Ship DXF file to vendor			
ŀ		Laser Cut flat pattern per Dwg D3321 Possible Supplier: Industrial Laser			
		Material release note is required	h	05-105-10	10
3	RG	Receive and inspect for transit damage	1		
		Ensure material release note is attached	にば	05/10/21	10
4	QC6	Inspect dimensions as per inspection template D3321-3T1	B	05-11-17	11)
5	GA	Deburr if necessary		NIK	
6	`GB	Form using DT8179 Die & DT8774 as per Dwg D3321 Dwg Rev:	51B	oslulas	8
7	QC6	Inspect dimensions as per Dwg D3321		US 12:01	3
8	ws	Weld hard surface using D3321-3T3 as per QSI 004 and Dwg D3321 Dwg Rev:			1
144.00	Ch				
		QtyPart NumberDescriptionBatchA/RN/A7560 Hardcoat Rod1/9474	a	05.12.19	9
9 ,	QC9	Inspect weld	W	85/12/19	9
10	FP	Powder Coat Grey Sandtex (Ref 4.3.5.6) as per QSI 005 4.3	FC	05 12 20	4
11	QC3	Inspect Powder Coat	M	05 12 21	9
12	ST	Identify on inside surface using a permanent fine point marker			
		with the following:			
		TCCA-PDA, Dart Aerospace Ltd. P/N: D3321-3, B/N: BXXXXX			
	,4	For Product Fligibility see PDA04-17	1		
		and Stock	Vo o	6/01/03	9
13	AC			///	
		Cost / part:	SCIC	06-01-04	۶
14	DC	Close W/O		المناه المناه	S
L	L <u>. </u>	Inspect Level 21		06/01/04) .

Rev	Date	Change	 Revised By	Approy6d
Α	05.05.12	New issue	KJ/JLM /	

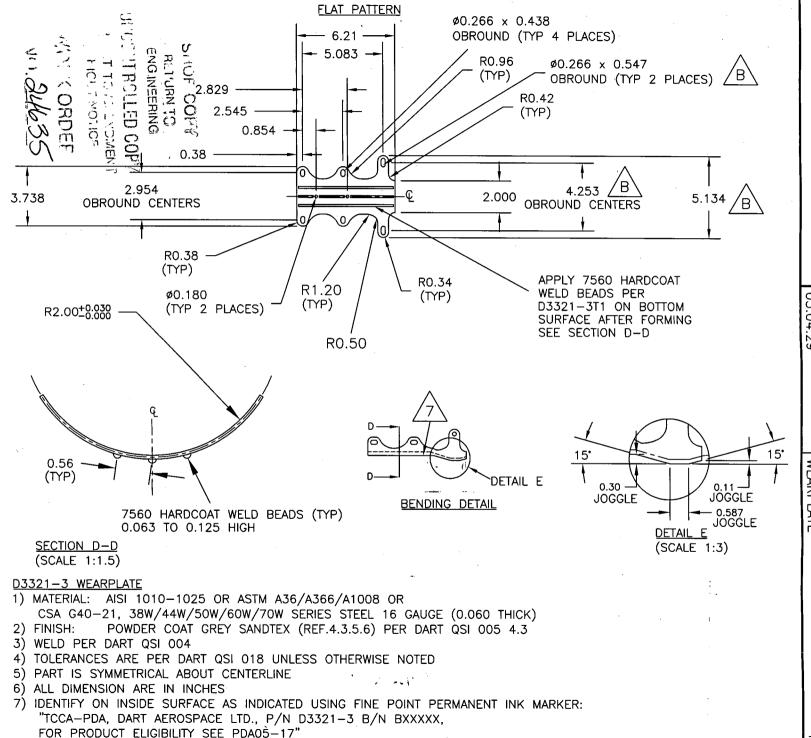
DDEI INNINARY ISSUE

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector			
		the same of the sa								
		y ;								

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE STEP		Description of NC		Corrective Action Section B	\/!5!4!		Τ.	
		Section A	Initial Design Mgr	Initial Action Description Sign &		Verification Section C	Approval Design Mgr	Approval QC Inspector
				•				
		,				-		,
		4						

Part No:	PAR #:	Fault Category:	NCR:	Yes No DQA:	Date: 06/01/04
NOTE: Date & initial all entries		·		QA: N/C Closed:	Date:



DELIMINAN ISSUE

WEARDIATE 1:6		05 04 29
TITLE SCALE		DATE
D3321 SHEET 2 OF 2		
DRAWING NO. REV. B	APPROVED	CHECKED
HAWKESBURY, ONTARIO, CANADA	2	五
DART AFROSPACE LTD	DRAWN BY	DESIGN

Job Costing Report

	UOD COSCING I	reporc	
Dart Aerospace Ltd.	1.5		Oct 20, 2005
Hawkesbury	, · · · · · · · · · · · · · · · · · · ·		04:09 pm
	,		-
Work Order No :	0024635	<i>y</i> ••	•
	D3321-3	Department Code:	
	·		NNNNNN
	WK543	9 .	
Work Order Type :	Main		Open
Main WO Number :	b		Not Invoiced
House Part Number:	D3321-3	Invoice Date	•
Description : Wea	rplate, Aft End	Invoice Number :	**
Manufactured : Yes		Invoice Amount	0.00
Amount Reg'd:	10		
Amount Done :	0	Order Entry No	
	10-20-05	OE Value	0.00
, -		Of value	0.00
	10-31-05	Dot Mossle II	0.000%
Act Finish Date :		Est Mark Up	
<u> </u>	No	Actual Mark Up	0.000%
Ok for Approval :			
Approval Rec'd :		\$0 Posted to Fir	nished Goods
		- X .	
-	Estimated Actual	Var. % Pos	sted To Post
=======================================	=======================================	=======================================	
Material Cost :	0.00 , 0.00	`~ ₀ 000	0.00
Engineering Hours :	0.00 0.00	0.00	•
Engineering Cost :		0.00	0.00
Production Hours* :		0.00	, .
Production Cost :			0.00
Packaging Hours :		0.00	\$1.
Packaging Cost			0.00
OverHead Hours	100 mg	0.00	
	· · · · · · · · · · · · · · · · · · ·		0.00
OverHead Cost :	•	·	0.00
CNC Hours :	0.00 0.00		0.00
CNC :	0.00		0.00
Misc. Hours :	0.00 0.00	0.00	
Misc. :	0.00	0.00	0.00
	=======================================	_======	
Burden :	0.00 / 0.00	0.00	
	_======================================	======	
Total Cost :	0.00 0.00	0.00	and the second second
Mark up :	0.000 0.000	• •	the second second
Selling Cost :			
	and the second s		· k
berring cobe .	0.00		

Actual 0.00 0.00

Estimated 0.00 0.00

Labour Hrs/Amount Done Profits/(Loss)





CHECKED E

APPROVED £

DRAWING NO.

HAWKESBURY, ONTARIO,

CANADA

AEROSPACE

DATE	SCALE
05.04.29 WEARPLATE	1:6
15.	

<u>FLAT_PATTERN</u>
Ø0.266 x 0.438 ———————————————————————————————————
5.093
2.829 (TYP) OBROUND (TYP 2 PLACES) B
2.545 (TYP)
0.854
0.38
2.954 3.738 OBROUND CENTERS 2.000 OBROUND CENTERS 5.134 B
OBROUND CENTERS OBROUND CENTERS OBROUND CENTERS OBROUND CENTERS
R0.38
(TYP) ;/ / \
Ø0.180 / R1.20 / R0.34 APPLY 7560 HARDCOAT WELD BEADS PER
D3321-3T1 ON BOTTOM
SURFACE AFTER FORMING . SEE SECTION D-D
R0.50
\mathfrak{q} $\frac{\sqrt{7}}{\sqrt{7}}$
15'
0.56
$0.30 \rightarrow 1.70 $
7560 HARDCOAT WELD BEADS (TYP) BENDING DETAIL JOGGLE 0.587
0.063 TO 0.125 HIGH
SECTION D-D (SCALE 1:3)
(SCALE 1:1.5)
D3321-3 WEARPLATE
1)
CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3 3) WELD PER DART QSI 004
1) MATERIAL: AISI 1010–1025 OR ASTM A36/A366/A1008 OR CSA G40–21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK) 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3 3) WELD PER DART QSI 004 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 5) PART IS SYMMETRICAL ABOUT CENTERLINE 6) ALL DIMENSION ARE IN INCHES 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA—PDA DART AFROSPACE LTD. P/N 0.3321—3 B/N BXXXXX
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 5) PART IS SYMMETRICAL ABOUT CENTERLINE 6) ALL DIMENSION ARE IN INCHES 7 OF THE REST OF T
6) ALL DIMENSION ARE IN INCHES 7) INCHES ON INCHES
7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: 1 5 1 5 5 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7
"TCCA-PDA, DART AEROSPACE LTD., P/N D3321-3 B/N BXXXXX,

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ANY

PURPOSE

OR .COPIED

- AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3 FINISH:
- WELD PER DART QSI 004
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- ALL DIMENSION ARE IN INCHES
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3321-3 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

Qty:

Each

10 Um:

: WEARPLATE

: D3321 REV. B

: 11/26/2005

: D33213

: B

Saturday, 11/19/2005 10:13:09 AM

User: Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 24635

Estimate Number

P.O. Number

This Issue

: 11/19/2005

: 10763

: NC

: //

: 24548

Type

S.O. No. :

: PURCHASED PARTS

Written By Checked & Approved By

Comment

Prsht Rev.

First Issue

Previous Run

: Est:

A 05.05.12 New issue KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: PURCHASING

PG 1.0



Comment: PURCHASING

Issue P/O:

Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3321 Possible Supplier: Industrial Laser Material release note is required

2.0 3.0

D33213F

PACKAGING 1

Wearplate, Aft End

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieive & Inspect for Transit Damage Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per inspection template D3321-3T1

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

BRAKE NC 6.0

NC BRAKE





Comment: NC BRAKE

1- Form using DT8179 Die & DT8774 as per Dwg D3321 Rev:



Saturday, 11/19/2005 10:13:09 AM Daire: User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: WEARPLATE** Job Number: 24635 Part Number: D33213 Job Number: Seq. #: Description: **Machine Or Operation:** 7.0 QC6 DIMENSIONAL CHECK **Comment: DIMENSIONAL CHECK** LARGE FABRICATION RESOURCE 1 8.0 LARGE FAB 1 **Comment: LARGE FABRICATION RESOURCE 1** Weld hard surface using D3321-3T3 as per QSI 004 and Dwg D3321 Rev: ____ Description Batch Part Number 7560 Hardcoat Rod A/R N/A QC9 VISUAL WELDING INSPECTION 9.0 Comment: VISUAL WELDING INSPECTION POWDER COATING POWDER COATING 10.0 Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 11.0 QC3 Comment: INSPECT POWDER COAT PACKAGING RESOURCE #1 12.0 **PACKAGING 1** Comment: PACKAGING RESOURCE #1 Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3321-3, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock Location: DOCUMENT CONTROL 13.0 DC



Comment: DOCUMENT CONTROL Inspection Level 21

Job Completion



Job Costing Report

Dart Aerospace Ltd. N Hawkesbury 1

Nov 08, 2005 12:41 pm

Work Order No : 0024635

Project Name : D3321-3

Project For : WK543 Work Order Type : Main

Main WO Number : Main

Main wo Number :

House Part Number: D3321-3
Description: Wearplate, Aft End

Manufactured : Yes

Manufactured : Yes

Amount Req'd: 10
Amount Done: 0

Amount Done : 0
Start Date : 10-3

Start Date : 10-20-05 Est Finish Date : 10-31-05

Act Finish Date : Drawings Reqd : No

Ok for Approval :

Approval Rec'd

Department Code:

Burden Flags : NNNNNNN WO Status : Open

Invoice State : Not Invoiced

Invoice Date

Invoice Number:

Invoice Amount: 0.00

Order Entry No :

OE Value : 0.00

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
=======================================	= = =		========		===========	=======================================
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	`3 0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0,00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	,	
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	~ 0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========	=======	======		
Burden	:	0.00	0.00	0.00	4	
		=======	========	======		
Total Cost	:	0.00	0.00	0.00	J	
Margin	:	0.000	0.000		v.'	
Selling Cost	:	0.00	0.00			

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) : 0.00 0.00